

# Work Order ID 81735

\*81735\*

Page 1

March-16-12 3:17:15 PM

Item ID: D3688-7 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: STUD  
 Start Date: 16/03/2012 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 23/04/2012 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3688	Rev <u>3</u>								
100	BAND SAW	0.00				5			
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	***DO NOT USE CHOP SAW***								
	Cut blank 9.724" long								
	<u>12/6/29</u>								
110	DOOSAN LATHE	0.00				5			
*110*									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA729 Rev: <u>11</u> & Dwg D3688 Rev: <u>C</u> 2-Deburr								
	per dwg D3688								
	3-Check .625" bore with DT9530 GO/NO GO Gauge								
	<u>12-6-30</u>								
160	QC2- Inspect parts off machine FAI/FAIB	0.00				5			
*160*									
QC	Memo	0.00							
Quality Control									
	<u>12-6-30</u>								

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81735

**\*81735\***

Page 2

March-16-12 3:17:15 PM

Item ID: D3688-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: STUD  
 Start Date: 16/03/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 23/04/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC8- Inspect parts - second check	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								
180		0.00							
<b>*180*</b>	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>17380</u> LPI Per ASTM 1417 LEVEL 2Certificate of conformaty is required								
190	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

*CHK 12/07/03*

*5 0*

*CL 12/07/09 (5)*

*P14/2/2 (5)*

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**NOTE:** Date & initial all entries

March-16-12 3:17:15 PM

Page 3

Setup Start **\*NS1\***

Stop **\*NS2\***

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

## Quality Control

5 \_\_\_\_\_ m/12.07.09

5 SA 12/02/09

OK 12/7/10

MUF  
12-07-09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 3:17:19 PM

Page 1

Work Order ID: 81735

\*81735\*

Parent Item: D3688-7

\*D3688-7\*

Parent Item Name: STUD

Start Date: 16/03/2012

Required Date: 23/04/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

Rev:A New Issue 08-01-29 JLM Verified By:EC  
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC  
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174PH-H900R1.000

Purchased

No

100

f

45.2000

1.0871

5.721579

\*M174PH-H900R1 000\*

\*\*

SL 12/6/29

17-4SS H900 ROUND BAR 1.00

## Location

## Loc Qty

## Loc Code

MAT030

45.2

117445

21.2

120767

24

121918

4.5 ft

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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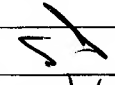
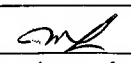




DART AEROSPACE LTD		Work Order:	81735
Description: Stud		Part Number:	D3688-7
Inspection Dwg: D3688 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.508	+/-0.010	.510	/			
0.438	+0.004/-0.000	.442	/			
1.42	+0.000/-0.03	1.410	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	R03	/			
0.07 Ref	+/-0.030	-.07	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.190	/			
1.025	+0.000/-0.010	1.020	/			
Ø0.659	+0.000/-0.015	.657	/			
9.624	+/-0.015	9.630	/			
2.90	+/-0.030	2.90	/			
3/4-16UNF-2A	N/A	2A	/			
0.075 x 45°	+/-0.010 x 0.5°	.075 x 45	/			
0.445	+0.000/-0.010	.440	/			
Ø0.189	+0.005/-0.001	.190	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 12/6/29	Date: 12/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ 	

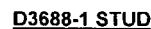
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**NOTE:** Date & initial all entries



- NOTES:**  
1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 1.24 lb  
8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 8/735 MCO

C	0.20 WAS 16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B5-3, B5-4); UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REDUCE LENGTH ON Q3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTO TYPE INSL.; Q.0.608 WAS Q.0.665 (ZN D8-1); Q.0.665 (ZN D8-1, D8-2, D8-3); Q.0.508 WAS Q.0.478 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV.
MFG. APPR.	<i>g</i>	D3688	SHEET 1 OF 1
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	STUD	NT
DATE	09.09.09	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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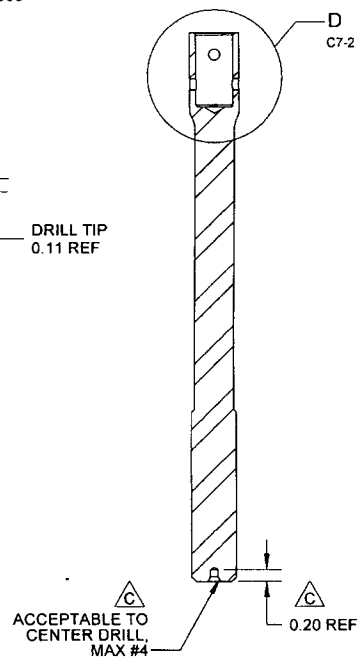
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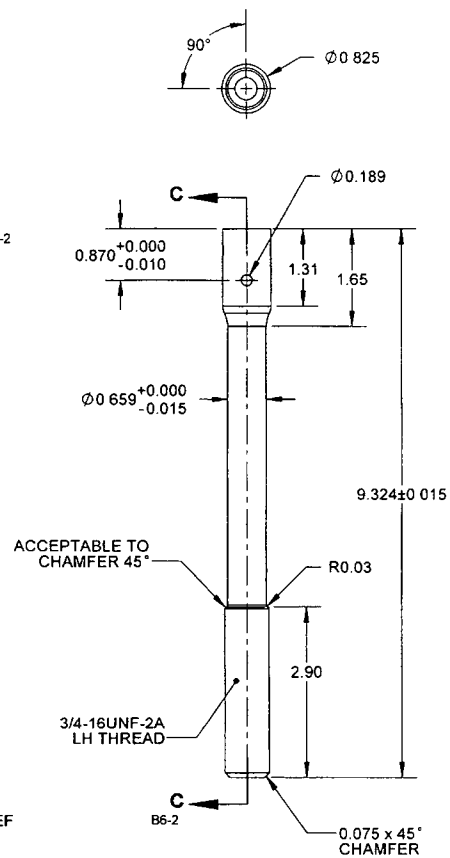
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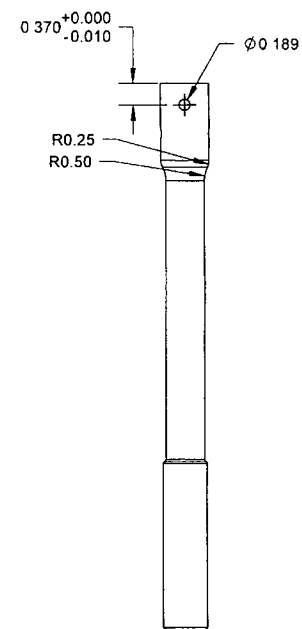
**NOTE:** Date & initial all entries



**SECTION C-C**  
D4-2



**D3688-3 STUD**



RELEASED  
2009-09-22  
[Signature]

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 0.97 lb  
8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3688</b>  TITLE <b>STUD</b>  COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF ANY TYPE OR BY ANY MEANS IS PERMITTED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. IT IS NOT TO BE USED OR FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT</small>	REV. C
DRAWN	RF		SHEET 2 OF 4
CHECKED	<i>g</i>		SCALE
MFG. APPR.	<i>g</i>		NTS
APPROVED	<i>g</i>		
DE APPR.	<i>g</i>		
DATE	09.09.09		

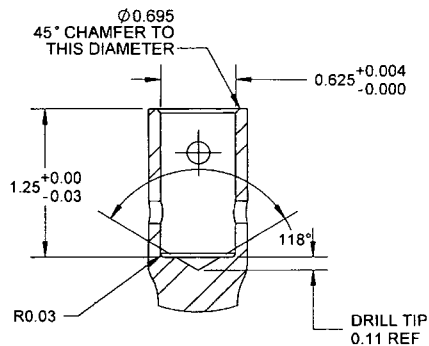
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

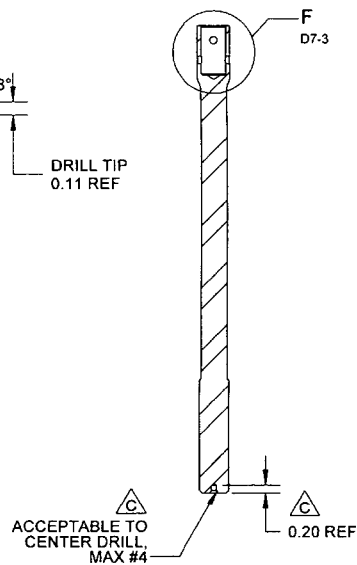
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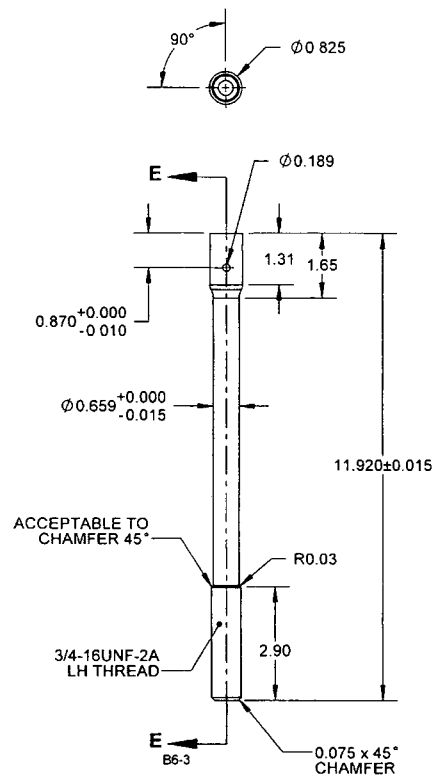
**NOTE:** Date & initial all entries



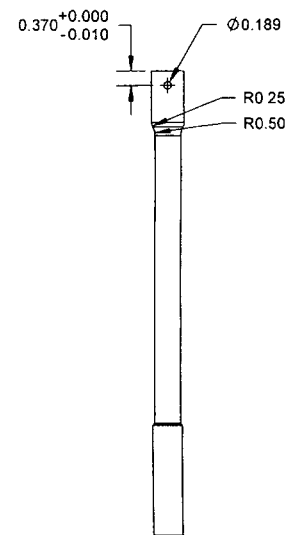
**DETAIL F**  
SCALE 3X  
D6-3



**SECTION E-E**  
D4-3



**D3688-5 STUD**



81735

**RELEASED**  
2009-09-22

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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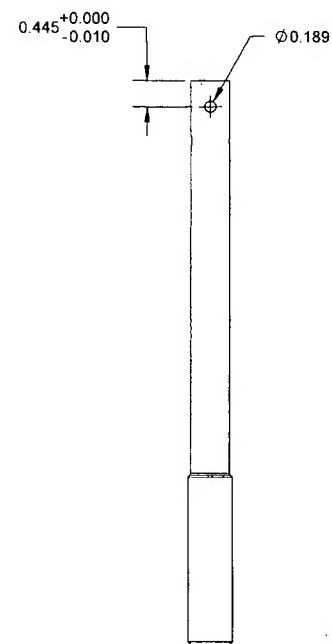
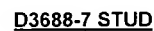
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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RELEASE  
2009-09-22

- NOTES:**  
1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5543 H-900 CONDITION  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
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CHECKED	<i>W</i>		SCALE
MFG. APPR.	<i>W</i>		NTS
APPROVED	<i>W</i>		
DE APPR.	<i>W</i>		
DATE	09.09.09		

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## LIQUID PENETRANT TEST REPORT

P- 12193

CLIENT ANT AeroSpace DATE July 6-2012 PAGE 1 OF 1  
ATTENTION LINDA/ANDY ACUREN JOB NO. 180-12-C0278 TIME AM ☒ PM ☐  
ADDRESS 1270 ABELEEN ST. HAWKESBURY PO/WO NO. [17380] —  
ON. WORK LOCATION SAME  
ACCEPTANCE STD ASTM 1417/051-038 REV./DATE 2008  
PROJECT FPI on Machined Parts  
ITEM(S) EXAMINED RAPPEL'S, STUD'S, SLEEVE'S

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE 2008 TECHNIQUE NO. LT-1417 REV./DATE 2008  
PART NO. SEE RESULTS MATERIAL STAINLESS STEEL THICKNESS VARIOUS  
SCOPE A WET FLOUORESCENT LIQUID PENETRANT EXAMINATION  
WAS COMPLETED ON SURFACE 100%

TEST DETAILS  
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER CASINO  
DEVELOPER SAFSS2 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE July 15, 2012  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE  
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

5	81735	✓
30	81733	✓
16	83359	✓
5	W.O. #	✓
5	RAPPEL	✓
15	W.O. #	✓
15	83358	✓

12 07 09

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar location. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE <u>Andy Sheldon</u> PRINT	<u>ASheldon</u> SIGNATURE	DTR # <u>E-163666</u>
TECHNICIAN (SIGNATURE): <u>[Signature]</u>		REPORT REVIEWED BY:
NAME (PRINT): <u>Alfred J. [Signature]</u>	2 <sup>ND</sup> TECHNICIAN	NAME INITIALS
CGSB LEVEL <u>2</u> SNT LEVEL	CGSB LEVEL SNT LEVEL	
CGSB REG. NO. <u>6606</u>	CGSB REG. NO.	